

# Work Order ID 68197

Friday, April 08, 2011 10:19:48 AM



fixed April. 12th Page 1

Item ID: D3589-3

Accept



Setup Start



Revision ID:

Stop



Item Name: ARM GUIDE

Start Date: 4/8/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *AFNF*

Date: 11.04.08 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3589

Rev B

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA754 & DWG D3589

FOLIO REV: *NA*

DWG REV: *5*

2-DEBURR AS REQUIRED

*rd 11.4.11*

*8*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*rd 11.4.11*

*8*

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Page 2

Item ID: D3589-3

Accept



Setup Start



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Stop



Item Name: ARM GUIDE

Start Date: 4/8/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/04/12

8

0

130

Identify as per dwg &amp; Stock Location: 11/A

0.00



Packaging

Memo

0.00

Packaging

EL

11-4-12

x8

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/12

11-04-12  
8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, April 08, 2011 10:19:45 AM

Page 1

Work Order ID: 68197

Parent Item: D3589-3

Parent Item Name: ARM GUIDE



Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-05-29 new issue DD verified by:EC  
09-02-20 rev.b asper dwg DD verified by:EC  
iPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R.500

Purchased

No

100

f

23.5600

0.05

0.421053



11-4-11

304 SS roundbar .500

Location

Loc Qty

Loc Code

MAT029

23.56

115334 ✓

23.56

1.5



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

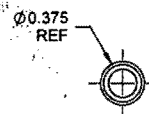
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

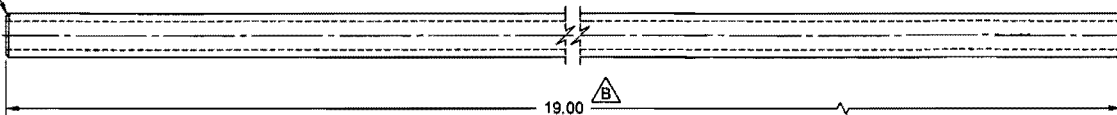
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

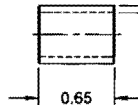
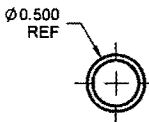


0.03 X 45°  
CHAMFER  
2 PL



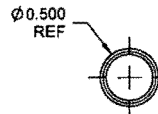
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REF

**D3589-1 ARM**



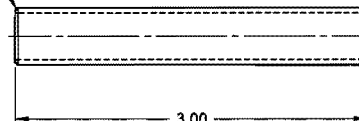
0.058  
REF

**D3589-3 ARM GUIDE**



#68197

0.03 X 45°  
CHAMFER  
2 PL



0.049  
REF

**D3589-5 LATCH GUIDE**

**D3589-1/-3/-5 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING  
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)  
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)  
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs  
- D3589-3 = 0.01 lbs  
- D3589-5 = 0.06 lbs

**RELEASED**  
9/12/25

DESIGN	<i>JA</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JA</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DS</i>	<b>D3589</b>	SHEET 4 OF 8
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>JA</i>	<b>LATCH ASSEMBLY</b>	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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